

Work Order ID: 74731



Wednesday, October 05, 2011 2:34:33 PM

Page 1

Item ID: D3477-1

Accept



Setup Start



Revision ID:

Item Name: Flange

Stop



Start Date: 10/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

HP

Date: 11/10/5

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3477	Rev B					5			
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							B12-6-27
FLOW CNC Waterjet	Cut as per Dwg D3477								
304.018	Dwg Rev: B								
	Prog Rev: B								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							B12-6-27
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

8/12/04/27



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept



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Revision ID:

Stop



Item Name: Flange

Start Date: 10/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

DAS
30
9-89

5

13/12/03

Small Fab

Memo

0.00

1-Deburr if necessary.

2-Form as per Dwg D3477 using Dt8858 A,B&C

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

68-6
27
DAS

13/12/03

5

Memo

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location: 5159

0.00

0.00

Memo

13/12/03 (5)

DAS
32
9-89

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 74731

Page 3

Wednesday, October 05, 2011 2:34:33 PM

Item ID: D3477-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Flange

Start Date: 10/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

13/12/04

13-12-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, October 05, 2011 2:34:36 PM

Page 1
T

Work Order ID: 74731



Parent Item: D3477-1



Parent Item Name: Flange



Start Date: 10/5/2011

Required Date: 10/14/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-02-07 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA  304/316 0.018 SHEET		Purchased	No			100	sf	94.8000	0.37 	1.48	⑤	2. 1812-6-27	

Location

Loc Qty

Loc Code

MAT020

94.8

117798

94.8

117799

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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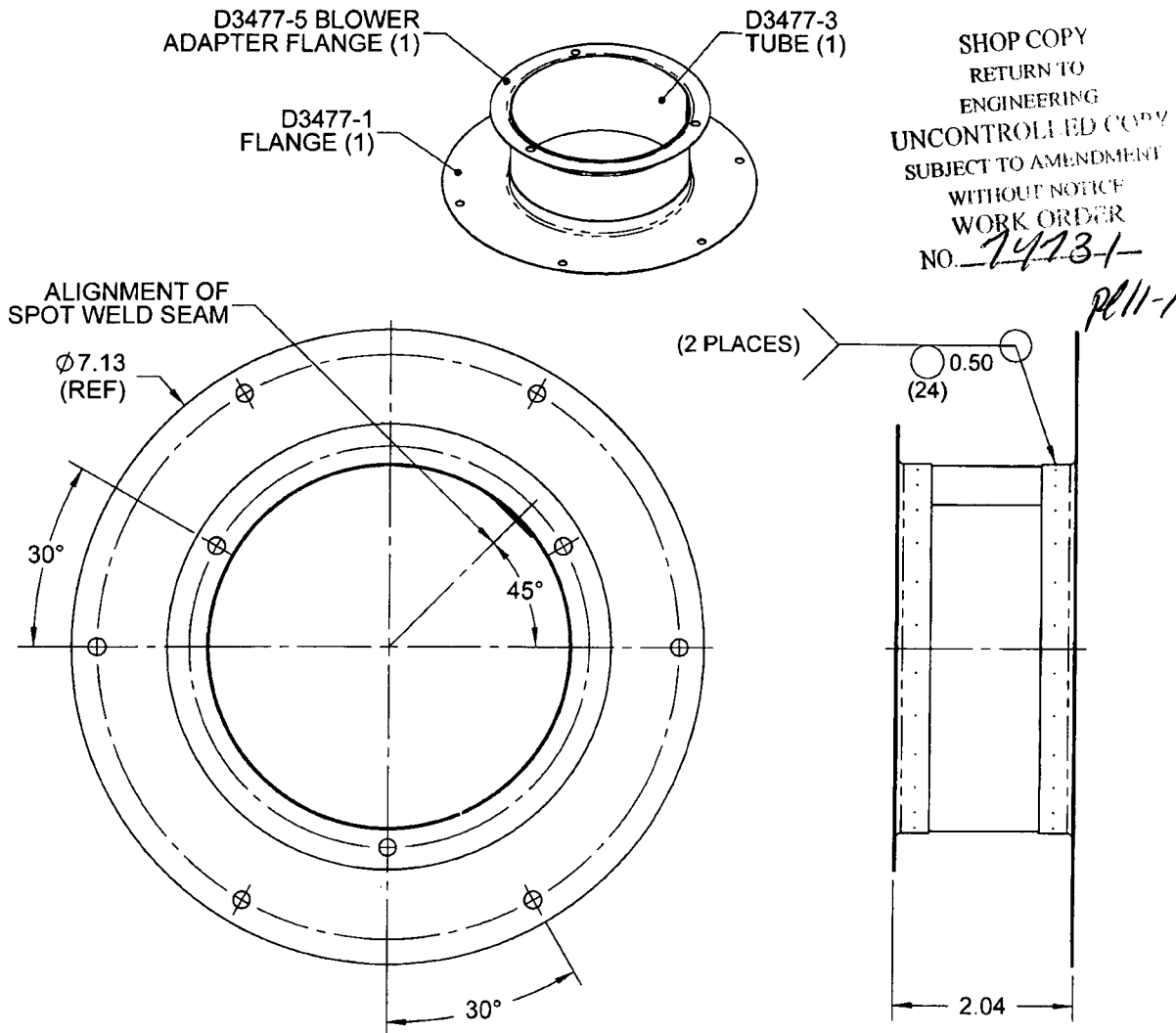
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
8/01/30

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RLH</i>	APPROVED <i>RLH</i>	DRAWING NO. D3477	REV. B SHEET 1 OF 4
DATE 08.12.19		TITLE BLOWER INLET ADAPTER	SCALE 1:2
A	05.12.09	NEW ISSUE	
B	08.12.19	$\phi 3.40$ & $\phi 4.1$ WERE $\phi 3.600$ & $\phi 4.14$ (SHT 2 & 4); ADD MFG NOTE AND TOL (SHT 3); MATL SPEC WAS MIL-S-5019	

**D3477-041 BLOWER MOTOR INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3477-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3477-041	BLOWER MOTOR ASSEMBLY
1	D3477-1	FLANGE
1	D3477-3	TUBE
1	D3477-5	BLOWER ADAPTER FLANGE

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

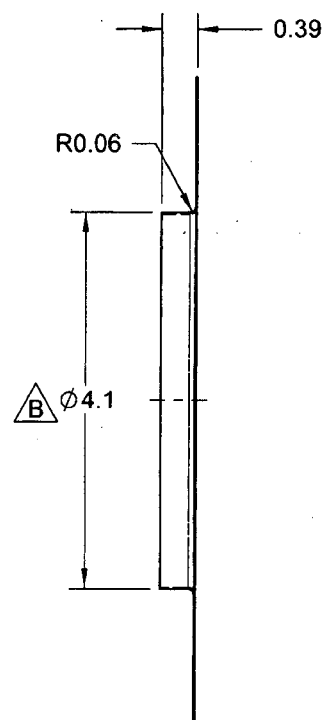
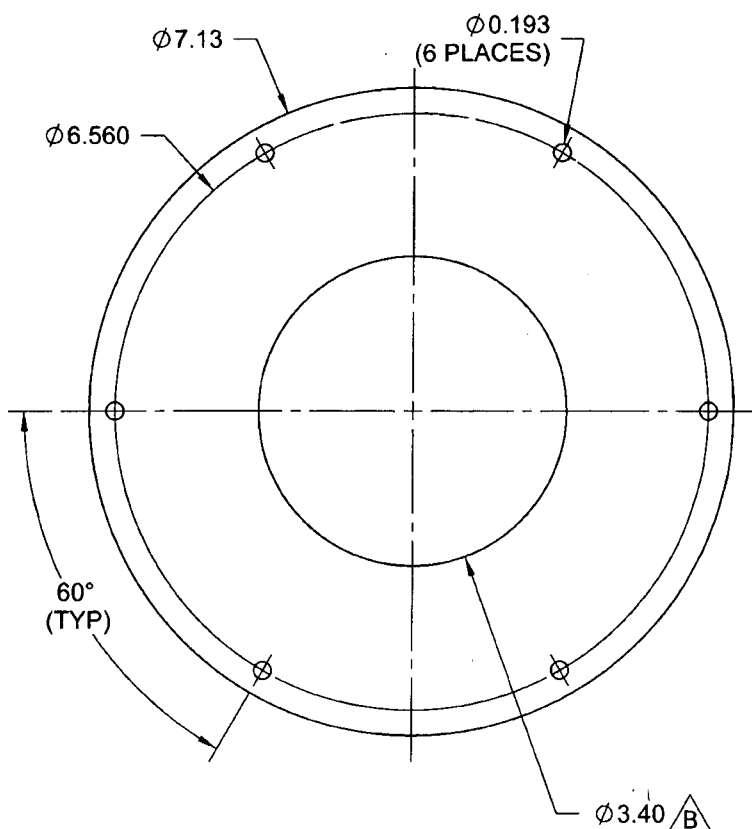
NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3477	REV. B SHEET 2 OF 4
DATE 08.12.19		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED
9/12/19

74731



**D3477-1F FLANGE
FLAT PATTERN**

**D3477-1
FLANGE**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle B$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector





Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

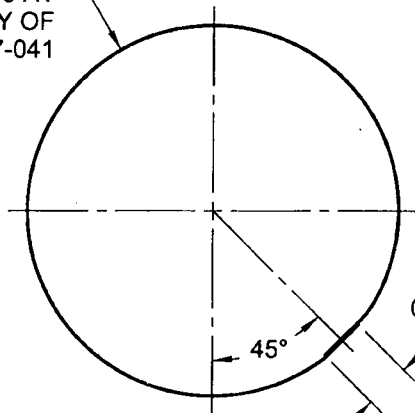
DART


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3477	REV. B SHEET 3 OF 4
DATE 08.12.19		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED
9/2/2014

74731

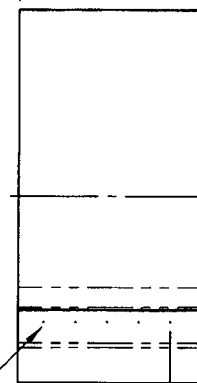
Ø4.10 (REF)
FORM TO FIT
D3477-1/-5 AT
ASSY OF
D3477-041



0.50^{+0.10}_{-0.00} 

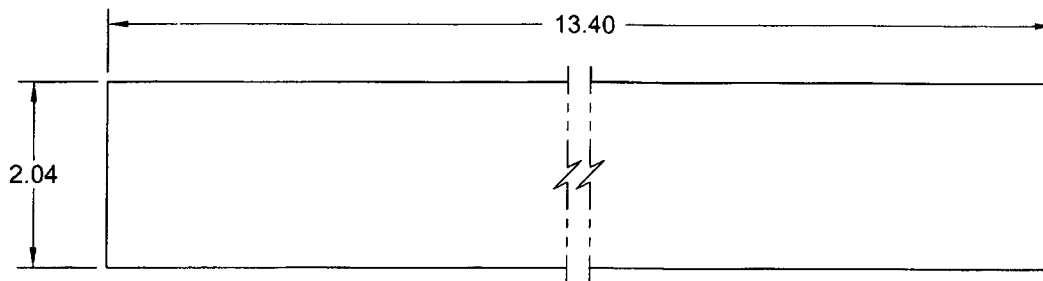
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
2.04
(REF)



0.38
(5)

0.35

D3477-3 TUBE**D3477-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH 
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

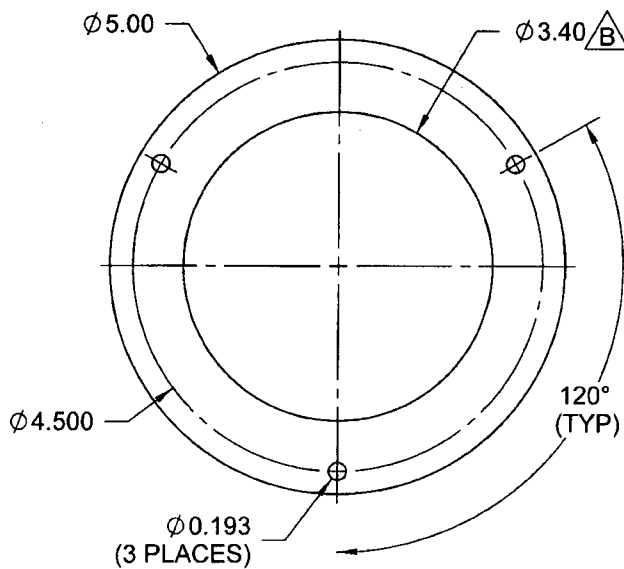
NOTE: Date & initial all entries



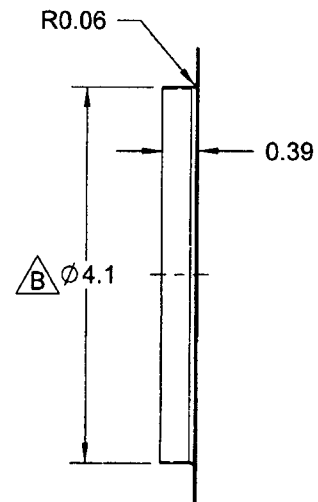
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3477	REV. B SHEET 4 OF 4
DATE 08.12.19		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED
[Signature]

14731



D3477-5F FLAT PATTERN



**D3477-5 BLOWER
ADAPTER FLANGE**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle B$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries